

Date: Tuesday, 4/17/2007 11:04:49 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER  
 Job Number : 31827  
 Estimate Number : 11591  
 P.O. Number : N/A Part Number : D2910  
 This Issue : 4/17/2007 S.O. No. : N/A Drawing Number : D2910 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A  
 Previous Run : N/A Material : N/A  
 Due Date : 4/24/2007 Qty: 20 Um: Each  
 Written By :  
 Checked & Approved By : 07.04.17  
 Comment : Est B 02.11.12 Re-format; Incorporated D2911 and D2912 K  
 J  
 Est Rev:C Now on Waterjet 07-01-23 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S090 6061-T6 .090 Sheet



Comment: Qty.: 0.1623 sf(s)/Unit Total : 3.2466 sf(s)  
 6061-T6 .090 Sheet  
 Material: Sheet 6061-T6 x 0.090" thick  
 (M6061T6S.090)  
 Batch: M19295

ml 07 04 18

(20)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D2910  
 Dwg Rev: A  
 Prog Rev: A

ml 07 04 18

(20)

2-Deburr if necessary > ml 07/04/18 x 20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 07 04 18

(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



07 04 18 (20)  
counted.

Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RE Date: 8/15/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:04:49 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 31827

Part Number: D2910

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form on CNC brake as per Dwg D2910, D2911, D2912 and QSI 034 4.1

SB 07/04/19 20

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2070420 (20)

(PTO)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/05/08 (20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/08 (20)

Job Completion

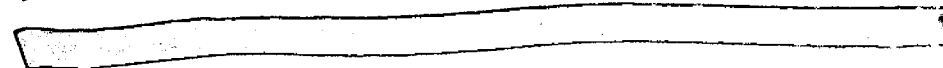


07/05/08




(20X)

→ 6.1 Acid etch & Abolone per QSI005

M-L 07/05/05



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-04-20	6-1	Acid: Alodine Per Dwg. Perm. Change 				 07-04-20	 07-04-20

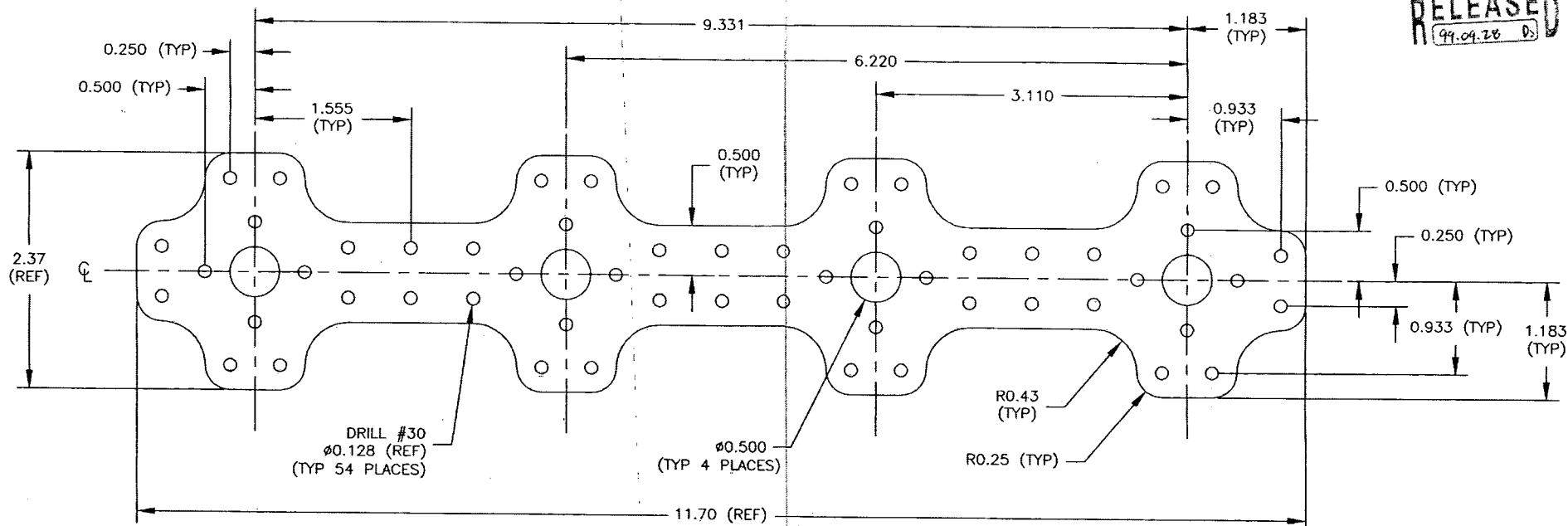
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

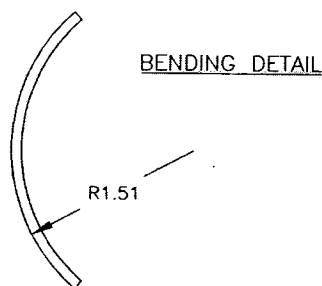
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED  
99.09.28 DS



FLAT PATTERN



MATERIAL: 6061-T6 SHEET (00-A-250/11) 0.091" THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

1.77  
WORK ORDER  
31827  
UNLESS OTHERWISE NOTED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
CONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

Copyright 1999 by DART AEROSPACE USA, INC.

A	99.09.07	NEW ISSUE
DESIGN CP	DRAWN BY RF	<b>DART</b> DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED CP	APPROVED RF	DRAWING NO. D2910 REV. A SHEET 1 OF 1
DATE 99.09.07	TITLE DOUBLER	SCALE 1:1

DART AEROSPACE LTD		Work Order: 31827
Description: Doubler		Part Number: D2910
Inspection Dwg: D2910 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.37	+/- 0.030	2.37	✓		VERN	
B 11.70	+/- 0.030	11.70	✓		MEASURING TAPE	
C 3.110	+/- 0.010	3.111	✓		VERN	
D 6.220	+/- 0.010	6.219	✓		VERN	
E 1.183	+/- 0.010	1.186	✓		VERN	
F 0.090	+/- 0.080	0.086	✓		VERN	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>AMM</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07 04 18	Date: 07 04 18	Date:	N/A
Rev	Date	Change	Revised by KJ/RF
		New Issue	Approved

*[Signature]*